

Date: Tuesday, 3/20/2007 1:51:35 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FWD X-TUBE	
Job Number	: 31365		Part Number	: D2889	
Estimate Number	: 10006		Drawing Number	: D2889 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/20/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 4/10/2007 Qty: 1 Um: Each	
Previous Run	: 31364		Type	: LANDING GEAR	
Written By					
Checked & Approved By					
Comment	: Est Rev.A		New Issue	05-10-25	JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6005180	Crosstube material	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Crosstube material	
		Pick: Qty Part number Description Batch	<i>EL 7-5-17</i>
1	D2889	Fwd Crosstube	<i>25673</i>
2.0	BENDING	"INE	
		Comment: LANDING GEAR RESOLUT <sup>ION</sup> 1-Bend D2889 as per	<i>EL/K 7-5-17</i>
3.0	LANDING GEAR 1	SOURCE 1	
		Comment: LANDING GEAR RESOURCE 1 1-Deburr and Polish	<i>N/A J</i>
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	<i>2005-02-01</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube	<i>N/A J</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: 120 Date: 07/05/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 31365

Part Number: D2889

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*NIA J*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *30 W/0 31376*

*J0705-22 ①*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*F07105/23 ①*

Job Completion



*W07105/23*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

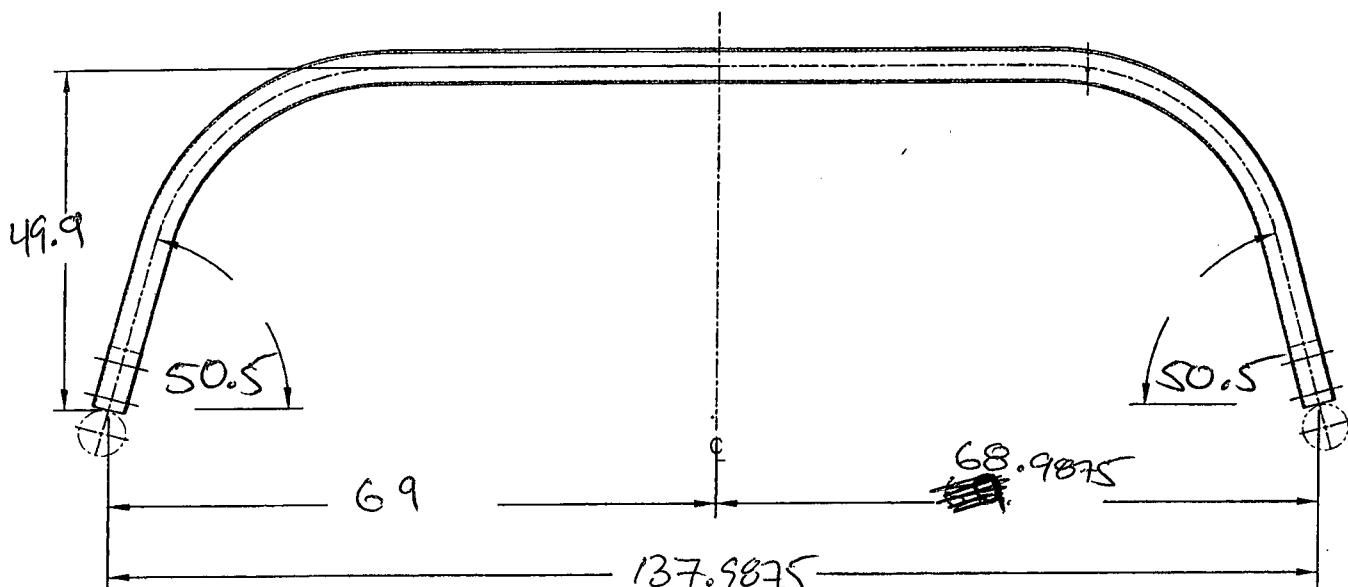
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31365
Description: Crosstube Fwd	Part Number:	D2889
Inspection Dwg: D2889	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
TUBE IS FOR D205-596-105 B31376. ALL DIMS ARE ACCEPTABLE FOR W/O 31376 AND THE -105 DIMENSIONS

QC15 Inspection	<i>JQS1042</i>
Date	0705.22

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[initials]</i>	<i>[Signature]</i>

**DART**

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

REV. B

SHEET 1 OF 1

DESIGN

CHECKED

DATE

TITLE

SCALE

DRAWN BY

APPROVED

DRAWING NO.

FWD CROSSTUBE

1:20

A

99.05.21

NEW ISSUE

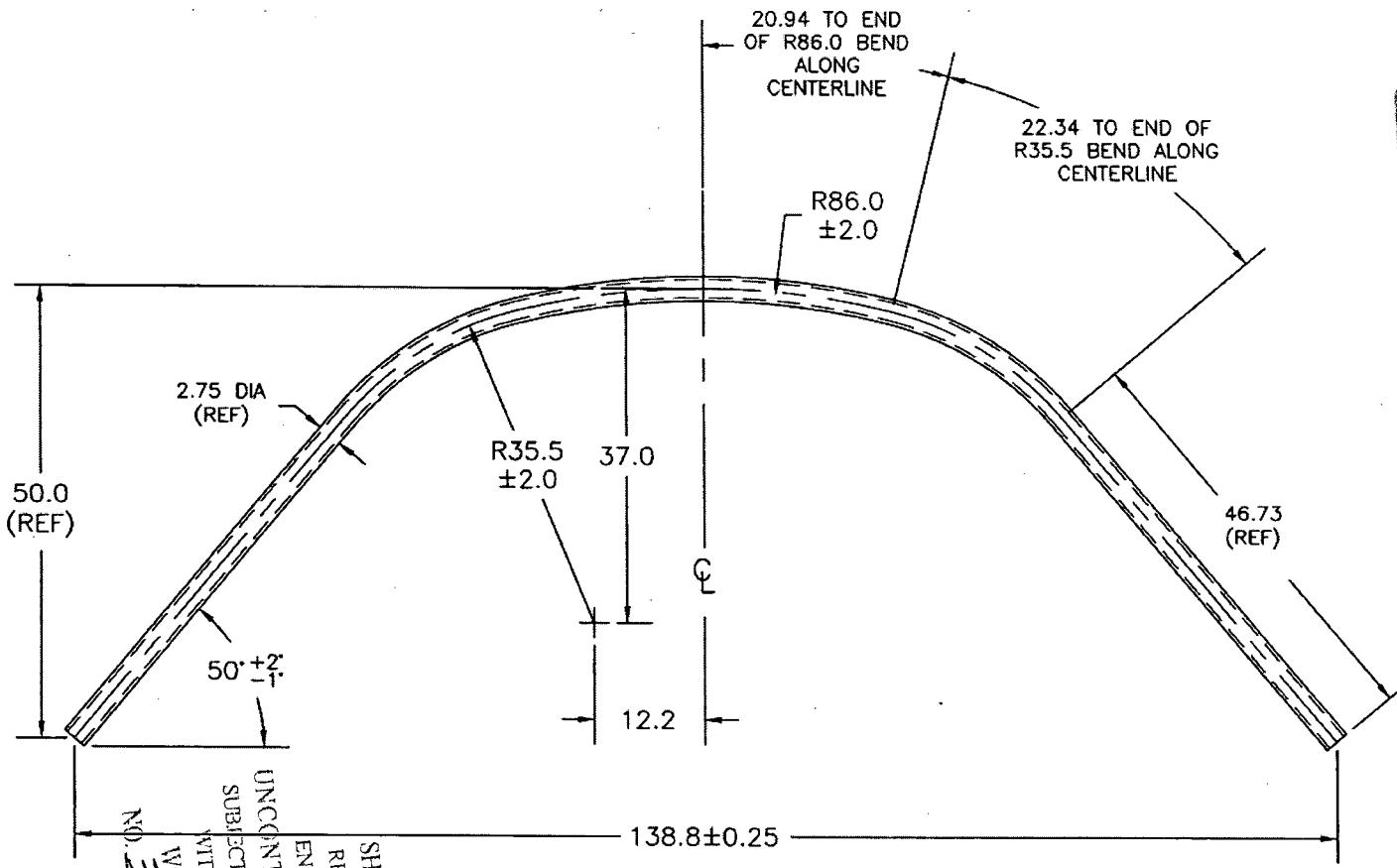
B

02.10.18

ADD TANGENT LENGTHS; CHANGE NOTES

**RELEASED**

02.10.28

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ( $\phi 2.75$  OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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WITHOUT NOTICE  
WORK ORDER  
NO. 21365

